

Work Order ID **55898**

February 4, 2010 8:50:44 AM

Page 1

Item ID: D4004-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Strap Attach Bracket

Start Date: 2/04/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: AK Date: 10-2-04 Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|----------|
| D4004 | A-PRELIM |
|-------|----------|

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-11 detail of dwg D4004

Ensure cut is started at correct place per dwg

Batch: B30209

2-Deburr

EF 10/02/10 (2)

105

0.00



Small Fab

Memo

0.00

Small Fab

Drill and c'sink holes as per dwg and trim part to length as required.

EF 10/02/16 (2)

PRELIMINARY ISSUE

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 55898

February 4, 2010 8:50:44 AM

Page 2

Item ID: D4004-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Strap Attach Bracket

Start Date: 2/04/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|-----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 110  QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | S 10/02/10 | | | (2) | | | |
| 120  HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | BH 10 02 22 | | | (2) | | | |
| 130  QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | =7 m.f 10/02/22 | | | (2X) | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries



Work Order ID 55898



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Page 3

Item ID: D4004-11 Accept  Setup Start 
Revision ID: Stop 
Item Name: Strap Attach Bracket
Start Date: 2/04/10 Start Qty: 2.00  Cust Item ID:
Required Date: 2/11/10 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|--------------------------|-----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 140  Packaging Packaging | Identify as per dwg & Stock Location: <i>Rael Shelf ST 110</i> Memo | 0.00 <i>E</i> 0.00 | <i>10.08.30</i> | | | <i>(2)</i> | | <i>10/09/01</i> | <i>(2)</i> |
| 150  QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | <i>10/09/01</i> | <i>(2)</i> |

BS 10-4-14
(2)

POSITIVE RECALL
EFFECTIVE *10/09/01* AUTH *U*
RELEASED *7* DATE *10.08.31*
Rev. 4.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

February 4, 2010 8:50:48 AM

Page 1

Work Order ID: 55898



Parent Item: D4004-11



Parent Item Name: Strap Attach Bracket

Start Date: 2/04/10

Required Date: 2/11/10

Comments: IPP rev A 09.12.15 new issue EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

40456-11-144

Purchased

No

100

Each

0.0000

0.8632



B-30209



SEAT TRACK

EB 5/10/12/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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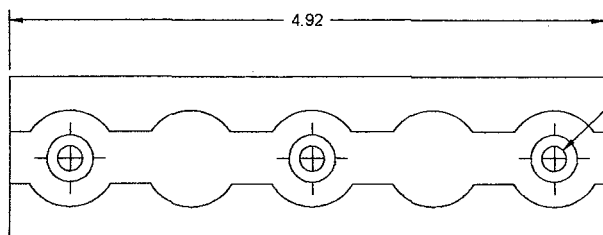
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

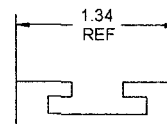
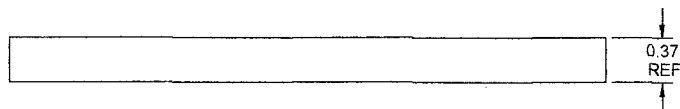
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

| DART AEROSPACE PART NUMBER | JOHN CAMERON AVIATION PART NUMBER |
|-------------------------------|--------------------------------------|
| D4004-11 | JCA-M47-2-11 |



DRILL $\varnothing 0.204$ (#6 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.385 \times 100^\circ$
3 PL



D4004-11 TOP STRAP ATTACH BRACKET

PRELIMINARY ISSUE
w/o 55898

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLIN P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

| | | |
|------------|----------|--|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4004 REV. A |
| MFG. APPR. | | SHEET 11 OF 11 |
| APPROVED | | TITLE SIDE RESTRAINT SCALE NTS |
| DE APPR. | | |
| DATE | 10.02.10 | |

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